

Date: Friday, 01/05/2009 11:20:02 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 47649		
Estimate Number	: 10725		
P.O. Number	:	Part Number	: D2652
This Issue	: 01/05/2009 S.O. No. :	Drawing Number	: D2652 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 46608	Material	:
Written By	:	Due Date	: 10/05/2009 Qty: 300 Um: Each
Checked & Approved By	: <u>SD 09.05.01</u>		
Comment	: Est Rev:B 02.06.13 Now machined in house. NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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0.0578 P/s) Unit

17.725 P/s)



Comment: Qty.: 0.0578 (s) Unit Total : 17.725 (s)

Material: 303 ss .500" Round Bar

(M303R0500)

Batch:

M111448

SD 09/05/06

2.0 HARDINGE

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV:

A

DWG REV:

A

2-DEBURR AS REQUIRED

SD 09/05/06

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 09/05/06 / 14 09.05.07

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SD 09/05/06

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST46

SD 09/05/11 304

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/05/2009 11:20:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 47649

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 *fg*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	4762
Description: Bushing		Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

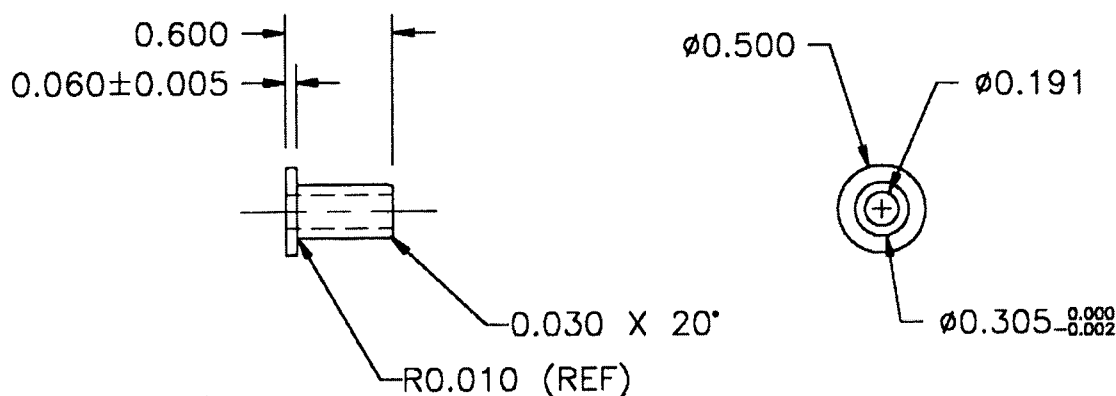
Measured by: <u>SD</u>	Audited by: <u>DJP</u>	Prototype Approval: <u>N/A</u>
Date: <u>09/05/06</u>	Date: <u>09/05/06</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	[Signature]



DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>BW</i>	APPROVED <i>MM</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *167049*

MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED